

Date: Tuesday, 7/24/2007 10:49:45 AM
 User: Jean-Luc Menard

Process Sheet

| | | | | | | |
|-----------------------|---------------------------------------|------------|------------------|----------------------|------|---|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : COVER | | |
| Job Number | : 33722 | | | | | |
| Estimate Number | : 12961 | | | | | |
| P.O. Number | : | | Part Number | : D36411 | | |
| This Issue | 7/24/2007 | S.O. No. : | Drawing Number | : D3641 UNDER REVIEW | | |
| Prsht Rev. | : NC | | Project Number | : AC0005 | | |
| First Issue | : / / | | Drawing Revision | : U/R | | |
| Previous Run | : | | Material | : | | |
| Written By | : | | Due Date | 7/31/2007 | Qty: | 2 |
| Checked & Approved By | : | | Um: | Each | | |
| Comment | : Est Rev:A New Issue 07-07-20 JLM | | Verified By:EC | | | |

Additional Product

PROTOTYPE

| | | |
|--|---|---|
| Job Number: |  | |
| Seq. #: | Machine Or Operation: | Description: |
| 1.0 | M6061T6S032 | 6061-T6 Sheet 0.032" |
| |  |  |
| Comment: Qty.: 0.8244 sf(s)/Unit Total: 1.6487 sf(s) M6061-T6 .032" THK sheet Batch: HB 07-07-30 HB 07-07-30 | | |
| 2.0 | WATER JET | FLOW WATER JET |
| |  |  |
| Comment: FLOW WATER JET 1-Cut as per Dwg D3641 Dwg Rev: PROTO HB 07-07-30 Prog Rev: TYPE | | |
| 2-Deburr if necessary | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| |  |  |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 07-07-30 | | |
| 4.0 | QC8 | SECOND CHECK |
| |  |  |
| Comment: SECOND CHECK B 07-08-07 | | |
| 5.0 | BRAKE NC | NC BRAKE |
| |  |  |
| Comment: NC BRAKE Form as per Dwg D3641-1 B 07-08-07 | | |

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5



ENGINEERING APPROVAL *u/s 07-08-08*



Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A

8.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

10.0 QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/24/08/15

Job Completion



FOR ENGINEERING USE ONLY

w/o 00/09

✓

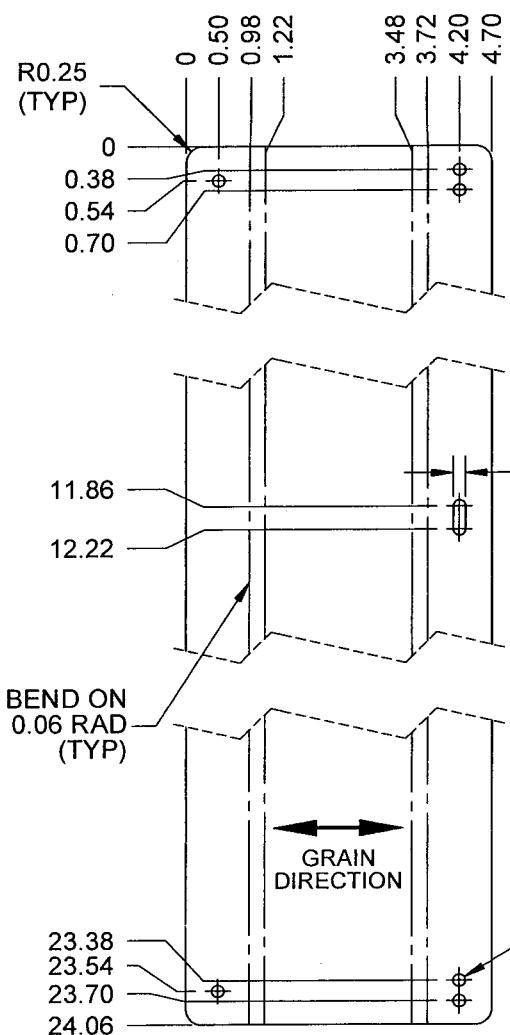
u 07-08-15

PROTOTYPE

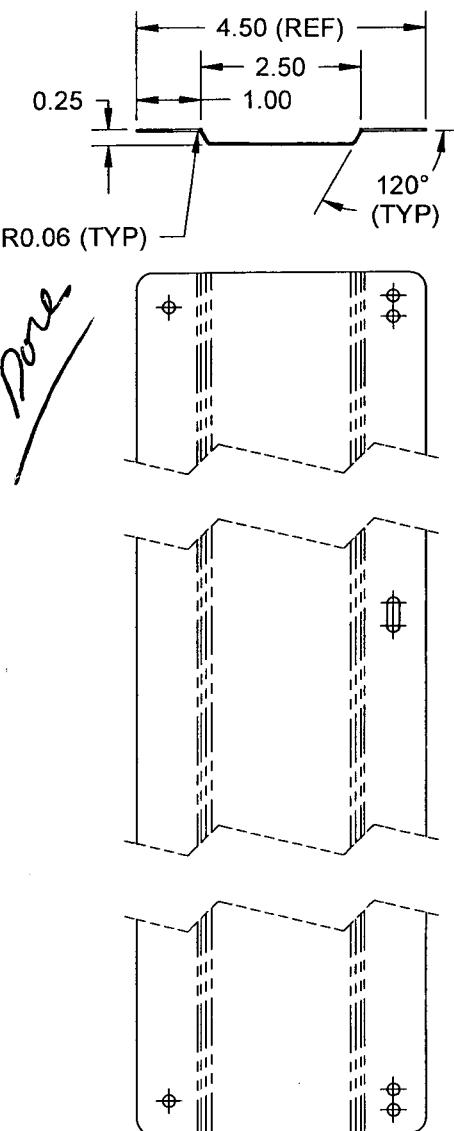
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

LE 07-07-17

| | | |
|------------------|------------------|---|
| DESIGN TS | DRAWN BY LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED B | APPROVED | DRAWING NO. D3641 |
| DATE 07.06.26 | | REV. A SHEET 1 OF 2 SCALE 1:3 |
| REV A | DATE 07.06.26 | DESCRIPTION NEW ISSUE; REPLACES G10606 |



D3641-1F FLAT PATTERN



**D3641-1 COVER
(REPLACES GENEVA P/N G10606-3/-6)**

NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.032 THICK PER QQ-A-250/11 OR AMS 4025/4027
(REF DART SPEC M6061T6S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

| | | |
|--------------------|----------------|-------------|
| DART AEROSPACE LTD | Work Order: | 33722 |
| Description: COVER | Part Number: | J3641-1 |
| Inspection Dwg: | Rev: PROTOTYPE | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| .38 | +/- .030 | .38 | X | | | |
| .70 | +/- .030 | .70 | X | | | |
| 11.86 | +/- .030 | 11.86 | X | | | |
| 12.22 | +/- .030 | 12.22 | X | | | |
| .54 | +/- .030 | .54 | X | | | |
| 23.38 | +/- .030 | 23.38 | X | | | |
| 23.54 | +/- .030 | 23.54 | X | | | |
| 23.70 | +/- .030 | 23.70 | X | | | |
| 24.06 | +/- .030 | 24.06 | X | | | |
| .50 | +/- .030 | .50 | X | | | |
| 4.20 | +/- .030 | 4.20 | X | | | |
| 4.70 | +/- .030 | 4.70 | X | | | |
| ∅ .191 | .005-.001 | .191 | X | | | |
| .032 | +/- .010 | .032 | X | | | |
| .191 | +/- .010 | .192 | X | | | |

| | | | | | |
|--------------|----------|-------------|--|---------------------|----------|
| Measured by: | HB | Audited by: | | Prototype Approval: | VS |
| Date: | 07-07-30 | Date: | | Date: | 07-08-08 |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |